

Date: Thursday, 10/18/2007 7:46:51 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LH ACTUATOR ASSEMBLY	
Job Number	: 35181		Part Number	: 41232 200 001 001	
Estimate Number	: 12761		Drawing Number	: 41232-200-001 REV IR	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/18/2007	S.O. No. : N/A	Drawing Revision	: IR	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/24/2007 Qty: 1 Um: Each	
Previous Run	: 31450				
Written By	: <u>10-07-10, 18</u>				
Checked & Approved By	: <u>10-07-10, 18</u>				
Comment	: Est Rev A New Issue 07-02-28 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MS208224	elbow
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) elbow Batch: <u>M104427</u>		
2.0	AN8424D	Elbow
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Elbow Batch: <u>M10 4156</u>		
3.0	41232 200 007 001	Brass Cylinder Assembly
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Brass Cylinder Assembly Batch: <u>B30942</u>		
4.0	MS1699623	cap screw
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) cap screw Batch: <u>M10 3937</u>		
5.0	AN3154R	Nut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Nut Batch: <u>M17566</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:46:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEBLY

Job Number: 35181

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M1057906

h

7.0 AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M105792

h

8.0 MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

Batch: M105588

h

9.0 AN322A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M3413

h

10.0 41232 200 005 003

Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer (Step Actuator)

Batch: 31022

h

11.0 41232 200 002 005

pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pivot arm

Batch: B31778

h

12.0 41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

latch

Batch: B31777 B35203

h 7/12/07 (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/01/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 7:46:51 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 35181

Part Number: 41232 200 001 001

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0 41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

tube

Batch: B31776

W

14.0 41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

Batch: MTO B31023

CC

15.0 S 1455

spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

spring-step actuator (replaces 71459)

BATCH: M104079

L 7/12/04 (1)

16.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

X1

2-Torque as per Dwg 41232-200-001

mul 08/01/16

17.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

108/01/16 (X1)

18.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPR 35059

AS 08/01/17 (X1)

19.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/17

Job Completion



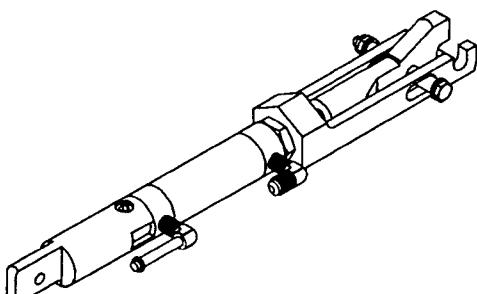
AS 08/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

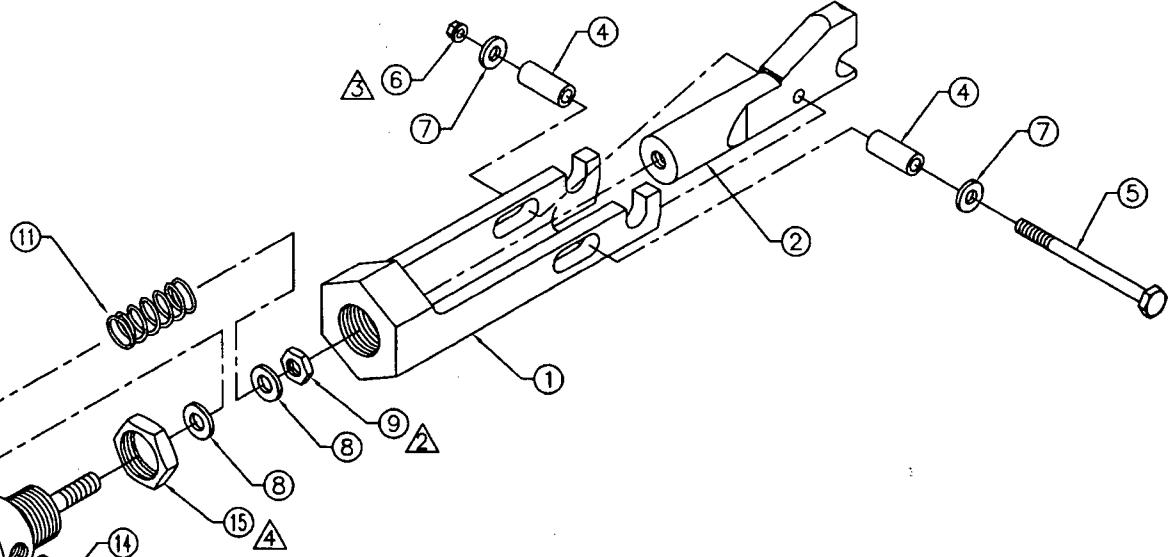
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

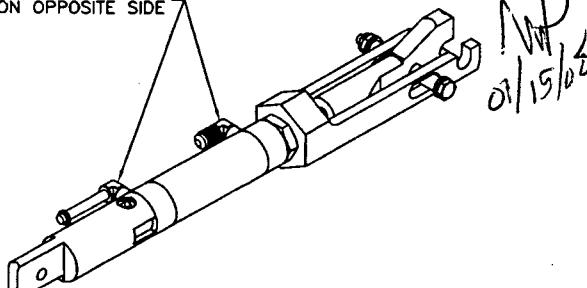
NOTE: Date & initial all entries



-001 L/H ACTUATOR ASSY



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASSY

-  TORQUE 80-100 IN.-LB.
-  TORQUE 20-25 IN.-LB.
-  TORQUE 50-75 IN.-LB.
-  TORQUE 50-75 IN.-LB.

NOTES:

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 3578!

1	1	15	3/4x20 BRASS	CYLINDER NUT			
1	1	14	MS20822-4	ELBOW			
1	1	13	AN842-4D	ELBOW			
1	1	12	41232-200-007-001	CYLINDER			
1	1	11	71459	SPRING			
1	1	10	MS16996-23	CAP SCREW			
1	1	9	AN315-4R	NUT			
2	2	8	AN960JD416	WASHER			
2	2	7	AN960JD10	WASHER			
1	1	6	MS21042-L3	NUT			
1	1	5	AN3-22A	BOLT			
2	2	4	41232-200-005-003	SPACER			
1	1	3	41232-200-002-005	PIVOT ARM			
1	1	2	41232-200-002-003	LATCH			
1	1	1	41232-200-002-001	TUBE			
			-002	R/H ACTUATOR ASSY			
			-001	L/H ACTUATOR ASSY			
-002	-001	RND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC
NO. REQ'D PER ASSY				LIST OF MATERIAL			ZONE

PROPRIETARY RIGHTS NOTICE				UNLESS OTHERWISE SPECIFIED X±.1 X0.±.03 XXX.±.010 ANGLES ±.1/2	DRAFTSMN D. NELSON	5/20/02	TITLE STEP ACTUATOR ASSY
	THESE DATA ARE PROPRIETARY TO ERA AVIATION, INC. REPRODUCTION OR DISCLOSURE OF THESE DATA FOR ANY PURPOSE OTHER THAN THE SPECIFIED PUR- CHASED BY THE VEND- OR, IS UNAUTHORIZED AND UNLAWFUL. A WRITTEN AUTHORIZATION FROM ERA AVIATION, INC. IS REQUIRED FOR ANY REPRODUCTION OR DISCLOSURE. DO NOT SELL TO VENDOR PARTS.				CHECK D. MURPHY	5/20/02	
002 001	1	41232-000-001				DWG. SIZE C	SCALE NONE
DRAWN BY RECD BY RECD PER ARCY		NEXT ASSEMBLY		REV.		DWG. NO. 41232-200-001	IR